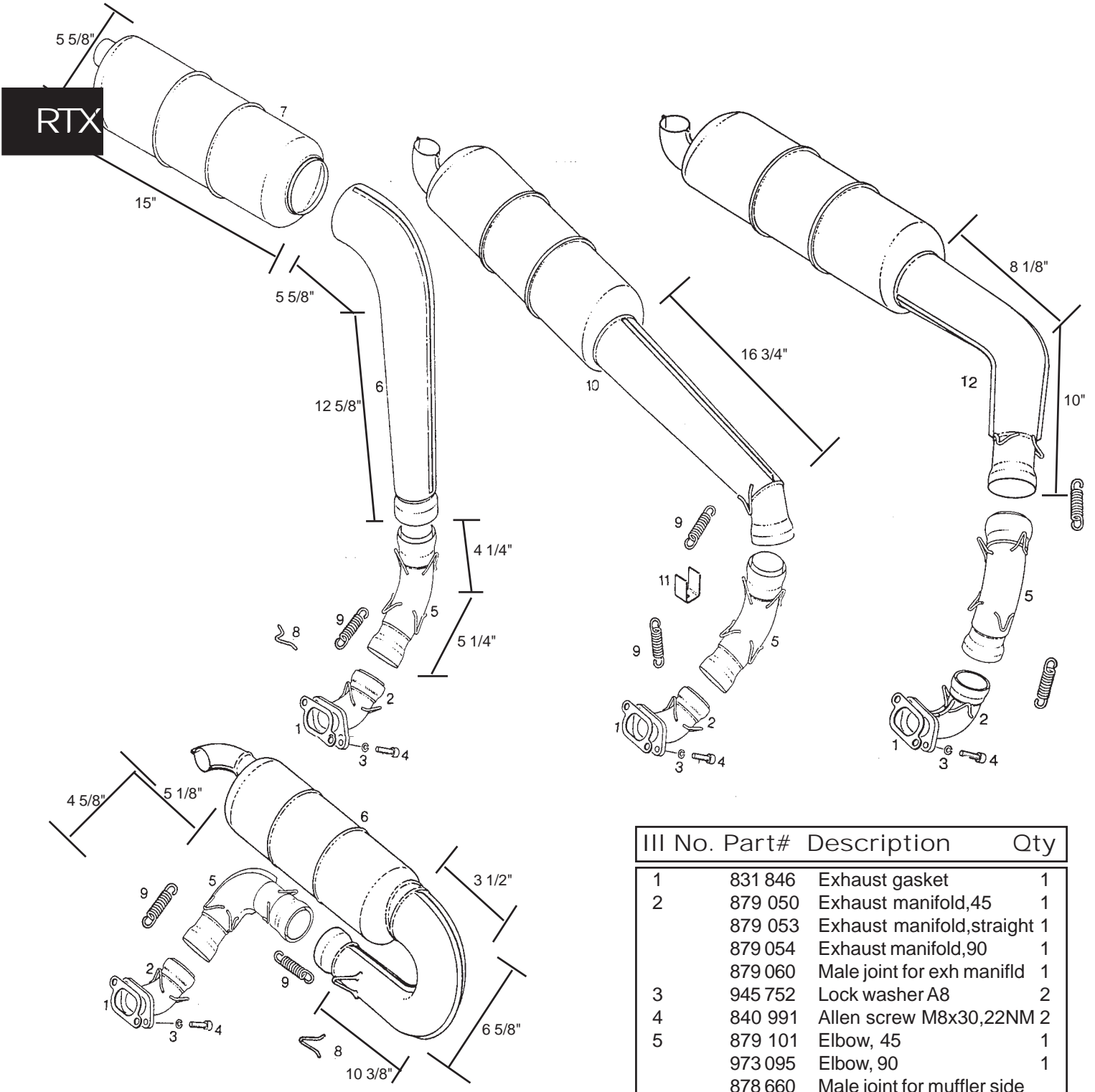


EXHAUSTS

277 SYSTEMS

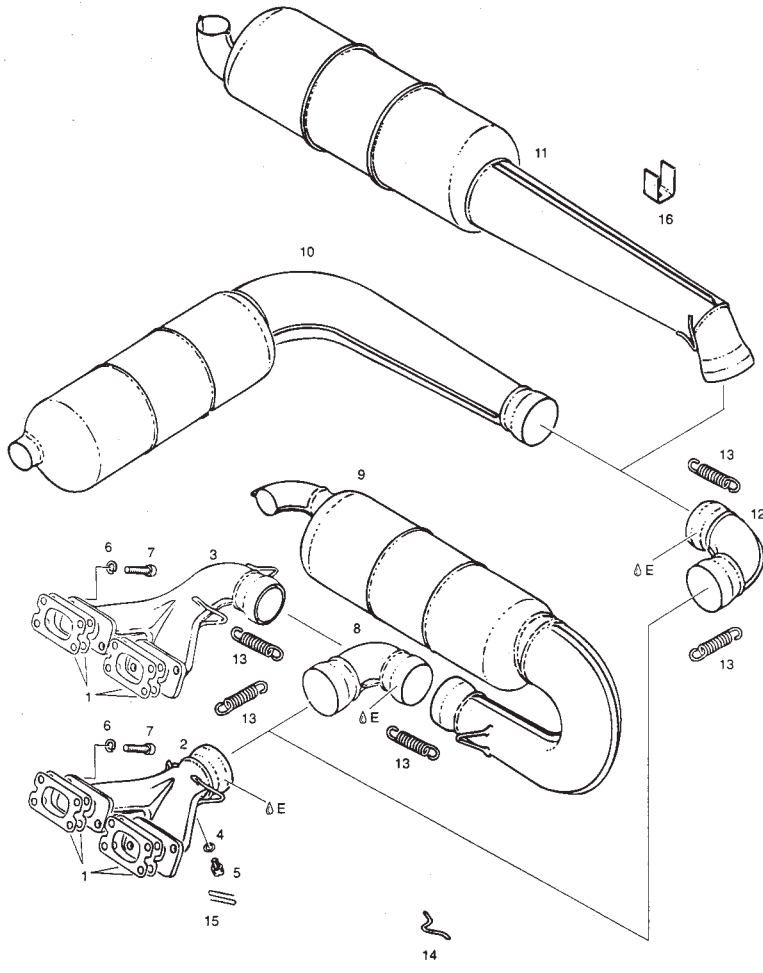


Ill No.	Part#	Description	Qty
1	831 846	Exhaust gasket	1
2	879 050	Exhaust manifold,45	1
	879 053	Exhaust manifold,straight	1
	879 054	Exhaust manifold,90	1
	879 060	Male joint for exh manifld	1
3	945 752	Lock washer A8	2
4	840 991	Allen screw M8x30,22NM	2
5	879 101	Elbow, 45	1
	973 095	Elbow, 90	1
	878 660	Male joint for muffler side of elbows	1
	879 190	Female joint for manifold side of elbows	1
6	879 830	Inlet cone assy	1
	973 198	Muffler assy, sidemount	1
7	973 175	Muffler can	1
8	853 355	Exhaust hook, stainless	12
9	938 795	Exhaust spring, 66mm	6
10	973 191	Muffler, straight	1
11	951 150	U bracket	2
12	973 203	Muffler, fisher type	1

STRAIGHT, 90 DEGREE AND SIDEMOUNT 377/447/503/532/582

EXHAUSTS

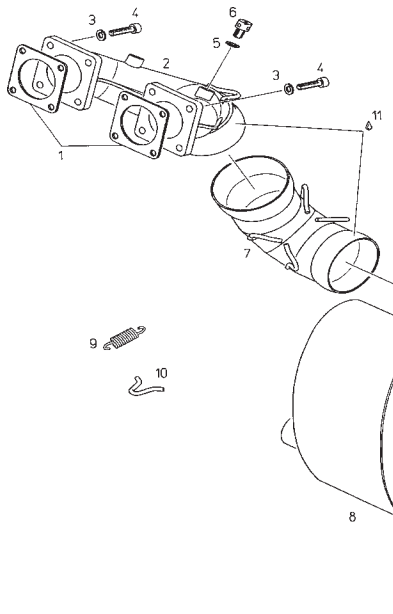
RTX



III No.	Part No.	Description	Qty
1	850 114	Exhaust gasket,377/447	4*
	831 849	Exhaust gasket,503CDI	4*
	831 842	Exhaust gasket,503PI	4*
	850 630	Exhaust gasket,532/582	2
2	979 380	Exhaust manifold,377/447,threaded	1
	878 937	Exhaust manifold,503, threaded	1
	973 121	Exhaust manifold, 532/582, threaded	1
	973 122	Exhaust manifold, 532/582,no holes	1
3	879 454	Exhaust manifold, 377/447	1
	879 144	Exhaust manifold,503	1
4	950 141	Gasket ring, A8x13	2
5	941 615	Capstan screw, M8x1x10	2
6	945 752	Lock washer A8,377/447/503	4
	945 752	Lock washer A8,532/582	8
7	840 991	Allen screw M8x30, 22NM	4**
	840 991	Allen screw M8x30, 22NM	8**
	940 366	Stud, M8	As Rqd
8	973 182	Connecting elbow w/hooks	1
	973 184	Connecting elbow w/hooks	1
	973 180	Connecting elbow,no hooks	1
9	973 198	Muffler assy, sidemount, 10 3/8" inlet for 377/447/503 3pc,532 2 pc	1
	973 197	Muffler assy, sidemount, 8 5/8" inlet for 532/582 3 pc	1
10	973 274	Muffler assy, 90 degree	1
	951 080	Brackets for muffler(not shown) and not included w/muffler assy	2
11	973 191	Muffler assy, straight for 377/4547/503,16 3/4" inlet cone	1
	973 192	Muffler assy, straight for 532/582, 15 3/4" inlet cone	1
12	973 180	Connecting elbow, no hooks	1
	973 182	Connecting elbow w/hooks	1
	973 184	Connecting elbow w/hooks	1
13	938 795	Exhaust spring, 66mm 377/447/503 two piece exh three piece exhaust	3 6
	938 790	Exhaust spring, 75mm 532/582 two piece exh three piece exhaust	3 6
14	853 355	Hooks, two piece exhaust three piece exhaust	6 12
15	SW032	Safety wire, .032 stainless	

*Fan cooled versions use 4, free air use 2
**If not all exhaust manifold bolts can be used, use stud listed with #242 206 8mm hex nuts and #945 752 lock washers

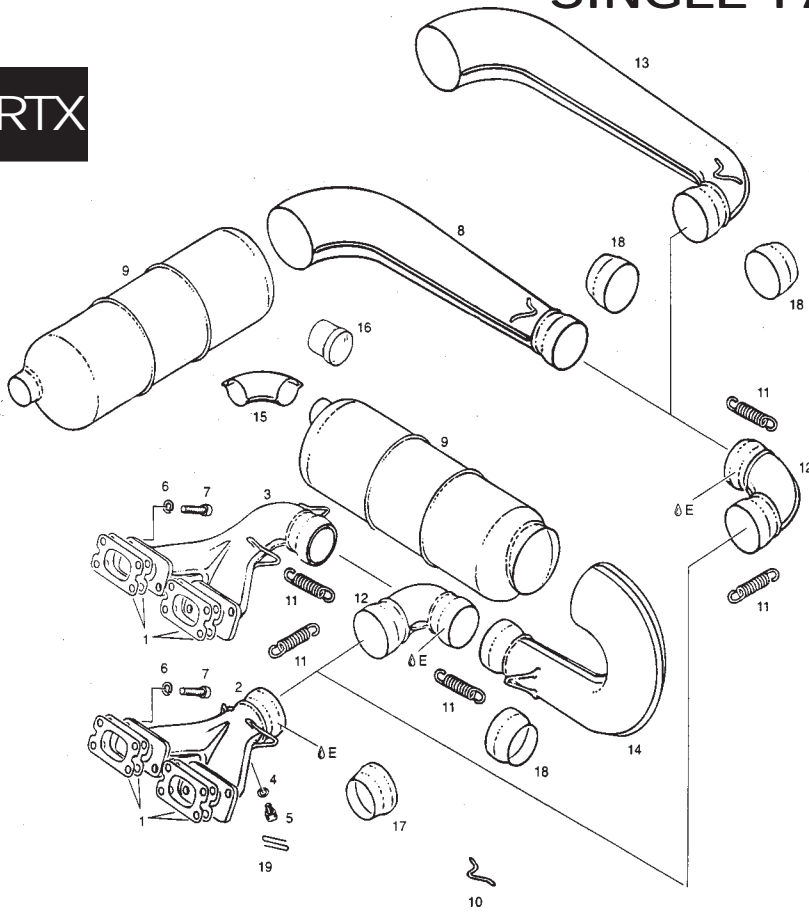
618 EXHAUST ASSEMBLY



III No.	Part No.	Description	Qty
1	850 552	Gasket	2
2	979 210	Exhaust manifold w/hooks	1
3	945 751	Lock washer A6	8
4	840 861	Allen screw M6x25,22NM	8
5	950 141	Gasket ring A8x13	2
6	941 615	Capstan screw M8x1x10	2
7	973 183	Exhaust elbow w/hooks	1
8	978 840	Muffler assy, sidemount	1
	978 845	Muffler assy, eipper	1
9	938 795	Spring 66mm	6
10	853 355	Hook, stainless	12
11	PSAS	Anti-seize	As Rqd
	842 755	Threaded weld on boss for 8mm egt probes,not shown	2

EXHAUST SYSTEM SINGLE PARTS

RTX



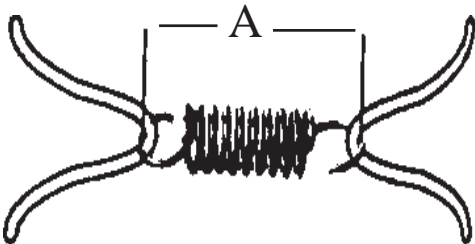
CONSTANT CRACKING OF INLET CONE IS USUALLY DUE TO EITHER INADEQUATE MUFFLER VIBRATION DAMPING OR LACK OF ANTI-SEIZE LUBRICANT ON MUFFLER JOINTS

****NUMBER OF BOLTS USED DEPENDS UPON MANIFOLD
377/447/503 USES 4, 532/582 USES 6.**

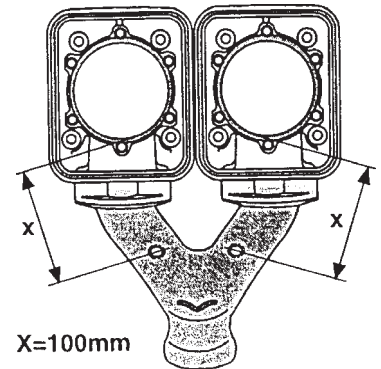
IllNo.	Part No.	Description	Qty
1	850 114	Exhaust gasket,377/447	4
	831 842	Exhaust gasket, 503PI	4
	831 849	Exhaust gasket, 503CDI	4
	850 630	Exhaust gasket, 532/582	2
2	979 380	Manifold assy, 377/447	1
	878 937	Manifold assy, 503	1
	973 121	Manifold assy, 532/582	1
3	879 454	Manifold assy,377/447	1
	879 144	Manifold assy, 503	1
4	950 141	Gasket ring 8x13	2
5	941 615	Capstan screw M8x1x10	2
6	945 752	Lock washer A8,377/447/503	4
	945 752	Lock washer A8,532/582	6
7	840 991	Allen screw M8x30,22NM	4**
	840 991	Allen screw M8x30,22NM	6**
8	973 546	Inlet cone assy	1
9	973 175	Muffler can assy	1
10	853 355	Hook,377/447/503	9
	853 355	Hook, 532/582	12
11	938 795	Springs, 66mm, 377/447/503	6
	938 790	Springs, 75mm, 532/582	6
12	973 180	Elbow, no hooks	1
	973 182	Elbow w/hooks	1
	973 184	Elbow w/hooks	1
13	976 540	Inlet cone	1
14	973 542	Inlet cone, 377/447/503	1
		and 532/582 two piece exh	1
	973 544	Inlet cone, 532/582 3 pc exh	1
15	879 920	Outlet elbow assy	1
16	978 640	Outlet tube assy	1
17	878 660	Ball joint, male	1
18	878 666	Ball joint, female	1
19	SW032	Safety wire, .032 stainless As Rqcd	
	842 755	Threaded weld on boss for 8mm EGT probes,not shown	2

SPRING INSTALLATION:

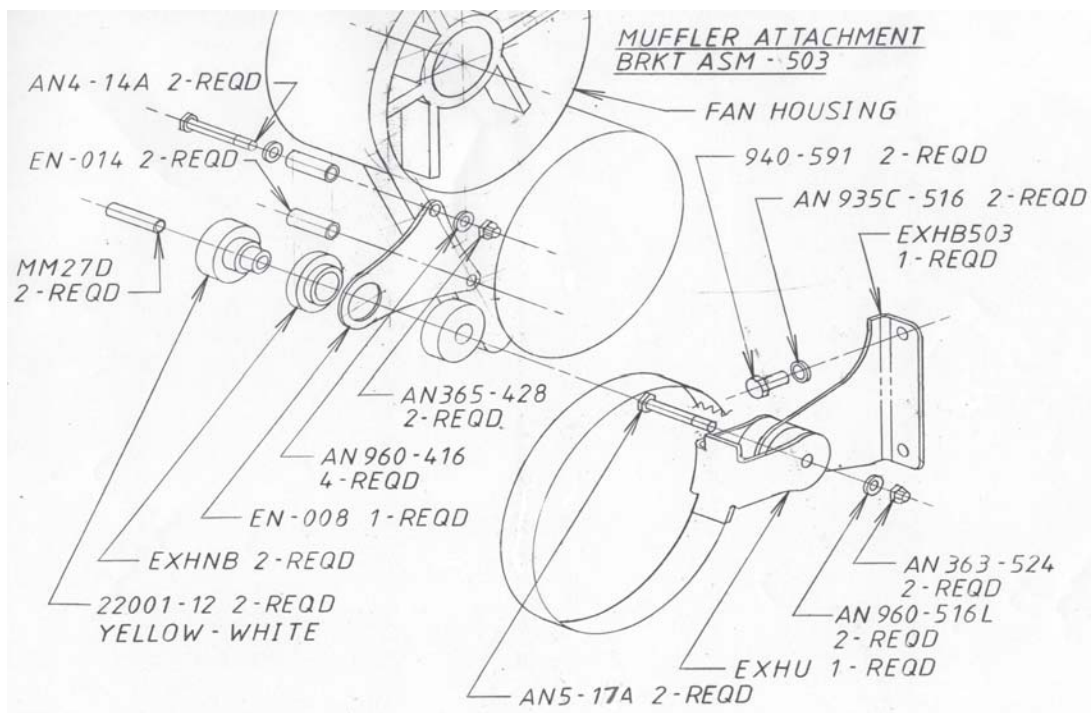
A = 938 790, 75MM (2.9") for 532/582
A = 938 795, 66MM (2.6") for 277,377,447,618,912



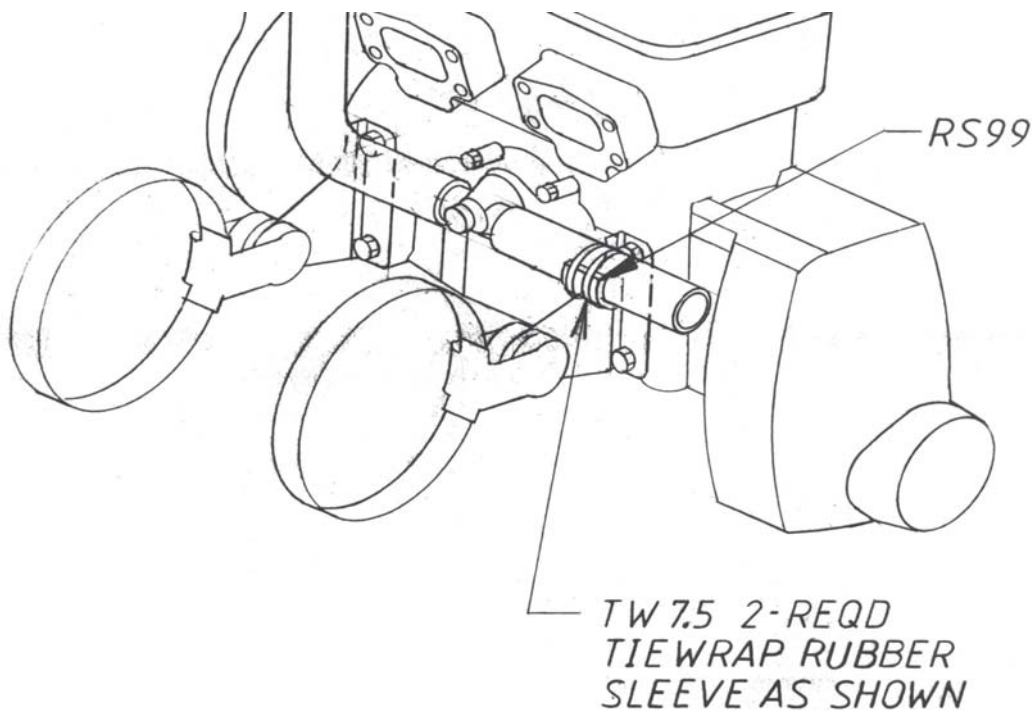
PROPER EGT PROBE PLACEMENT IS REQUIRED FOR VALID EGT READINGS. Probe must be 100mm or 3.92" from the piston face as shown.



503 Exhaust Mount Kit, #EMK503, \$99.95. Includes all items shown but fan housing. Mounts exhaust in the down position only.



582 Exhaust Mount Kit, #EMK582, \$99.95. Mounts exhaust in the down position only. 582-99 Installation shown with rubber buffer to protect radiator hose.



EXHAUST CLAMP KIT, Alternative to welding hooks and using springs. Includes hardware and 4 stainless brackets. 1 kit required per joint.
 Rotax 2 strokes (all but 618)#EXHCK, \$39.95 per kit
 Rotax 912/912S, #EXHCK9, \$42.95 per kit

